

Work Order ID 50337

July 14, 2009 2:45:41 PM



Page 1

Item ID: D3120-4

6Y

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 7/15/09

Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: C209107114

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3120

Rev B

110

0.00



HAAS CNC VERTICAL MACHINING #1

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3120

Prog rev: B

Dwg rev: B

Deburr as required

HB 9-8-12

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-8-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50337

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

⇒ 508/08/13

(43)

6

QC

Memo

0.00

SP 02/09/14

(3)

0

Quality Control

135 Bend as per dug

136 QC S

⇒ 508/02/15

(43)

0

140

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ JH 09/09/15

X3

0

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11/109091

⇒ JH 09/09/17

(43)

0

Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30pm

OVEN TEMPERATURE:

12:00pm

FINISH TIME:

320°F

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 7/15/09

Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

BF 09-09-18

(2)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/9/18 BX SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/18 HJ
MF 09-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 2:45:41 PM

Work Order ID: 50337

Parent Item: D3120-4RevB

Parent Item Name: Cover

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	111.0100	0.7295	3		



2024-T3 .032 sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

111.01

102942

1.5

105555

5

106272

8.47

108595

3

109240

7.02

110778

34.02

111699

49

18147

3

111699

B 8-9-17

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

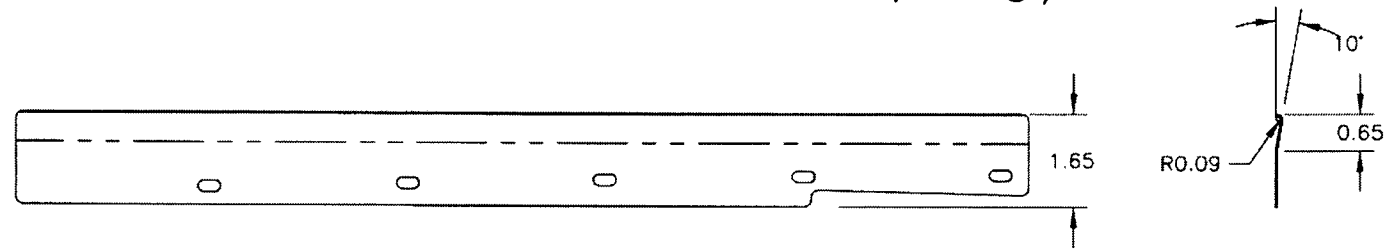
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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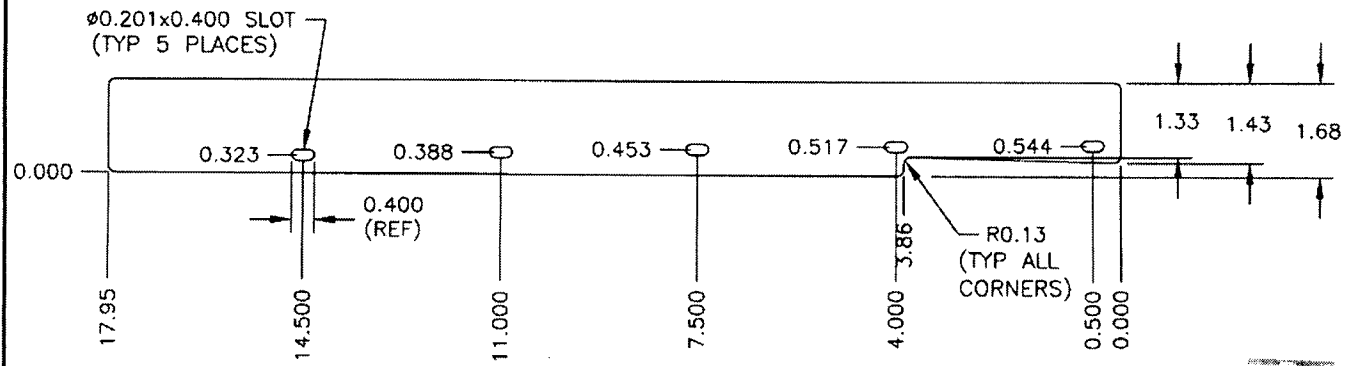
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
04.10.18	COVER	SHEET 1 OF 2
A	02.04.15	NEW ISSUE
B	04.10.18	ADD PART MARKING

C209107114
W/O: 50337



BEND DETAIL

D3120-1 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-229)
D3120-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-230)



D3120-1/-2 COVER. FLAT PATTERN

D3120-1/-2 NOTES

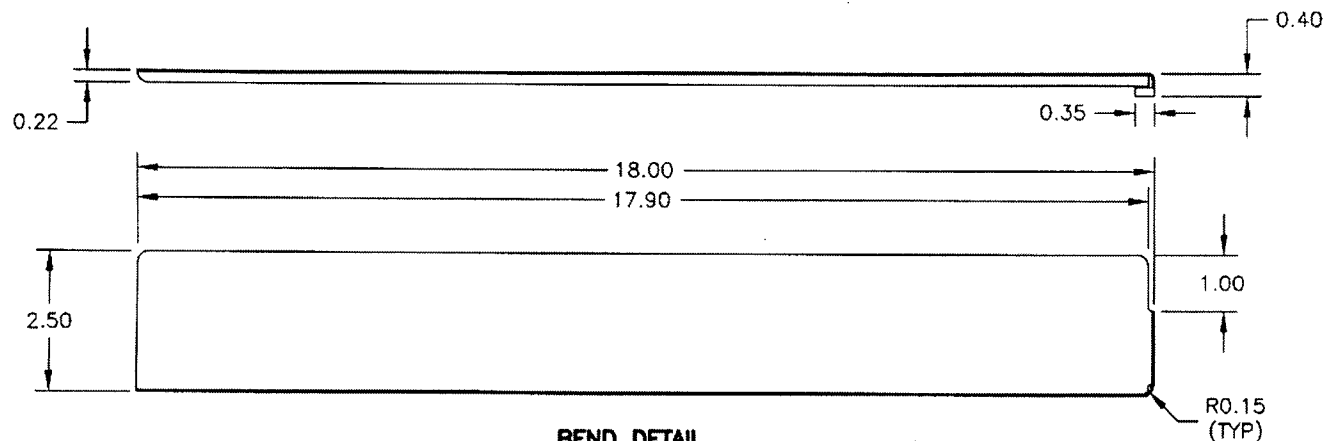
- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

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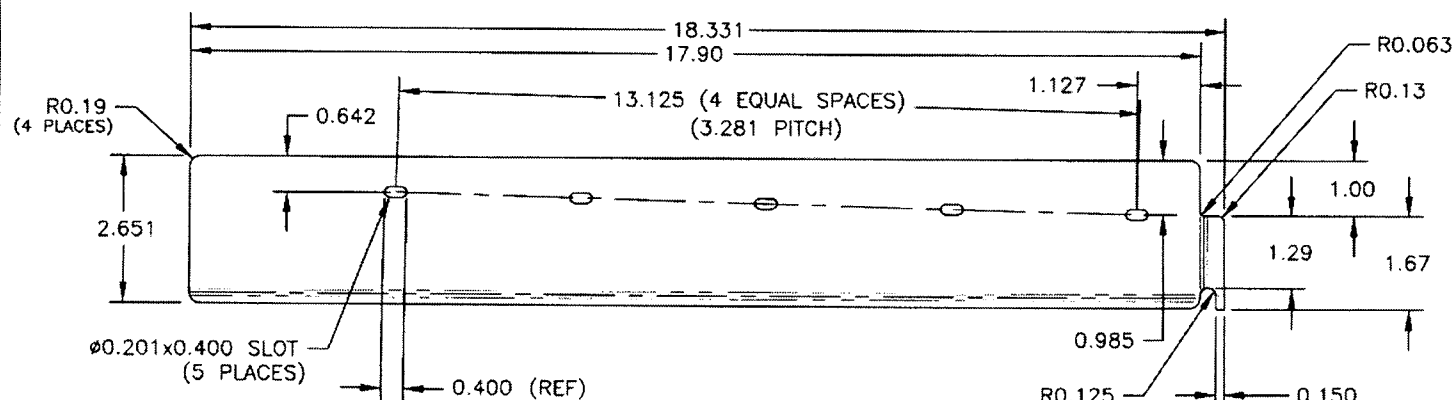


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4	14	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
14	14	D3120	SHEET 2 OF 2
DATE	TITLE	SCALE	
04.10.18	COVER	NTS	



BEND DETAIL

D3120-3 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-231)
D3120-4 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-232)



D3120-3/-4 COVER, FLAT PATTERN

D3120-3/-4 NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

50337

RECEIVED
04.10.18